

ABSTRACT OF THE DISCLOSURE

A one-way clutch integrated with a rolling bearing in which the workability of an assembling process including filling of grease is excellent, and the flowability of the
5 grease between the inner and outer races is so high that the life can be expected to be prolonged, and also a method of producing such a one-way clutch are provided. An annular flat plate portion 51b for sealing an annular space between an inner race 1 and an outer race 2 is integrally
10 formed in one of two annular members 51 and 52 constituting a cage 5. A radial through hole 51e which passes in a radial direction is formed in the one annular member, and an axial through hole 52f which axially passes is formed in the other annular member.

15 Steps 10 and 20 are disposed between shoulder portions 1c and 2c of rolling bearing raceway surfaces 1a and 2a of the inner race 1 and the outer race 2, and one-way clutch raceway surfaces 1b and 2b, whereby a J space formed between the one-way clutch raceway surfaces 1b and 2b can be
20 widened to enable larger sprags 4 to be used, without causing the whole size to be increased. In the outer race 2 of the rolling bearing, the rolling bearing raceway surface 2a and the one-way clutch raceway surface 2b are formed, and, in the inner race 1, only the rolling bearing raceway surface 1a is formed. The outer peripheral sides of the
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sprags 4 make contact with the outer race 2, and the inner peripheral sides are in direct contact with a shaft S, so as to transmit a torque between the shaft S and the outer race 2.

5 The inner race 1 and the outer race 2 are processed so that a radial dimension difference between the rolling bearing raceway surface 1a or 2a and the one-way clutch raceway surface 1b or 2b is within a predetermined tolerance with respect to dimensions that are set respectively
10 for the raceway surfaces. The inner race 1 and the outer race 2 are matched and incorporated so as to obtain an initial radial gap at which, in a state where the inner race 1 and the outer race 2 are fitted to respective counterparts, a radial gap of the rolling bearing has a preset value.